

54389 De Rev.

Work Order ID 54132

December 1, 2009 8:48:21 AM



Page 1

Item ID: D3852-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly

Start Date: 02/12/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: PTDate: 07-12-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rdd Batch: H 108735

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

SAD 09-12-02

8P 09.12.04. (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54132

December 1, 2009 8:48:21 AM



Page 2

Item ID: D3852-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly

Start Date: 02/12/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 09/12/09

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

>> 8 02/12/07



4

150

Identify as per dwg & Stock Location: *Basket*

0.00



Packaging

Memo

0.00

Packaging

11 09-12-08 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54132

Page 3

December 1, 2009 8:48:21 AM

Item ID:	D3852-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Rib Assembly					
Start Date:	02/12/2009	Start Qty: 2.00				
Required Date:	08/12/2009	Req'd Qty: 2.00				
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/12/08

MF 09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 1, 2009 8:48:35 AM

Page 1

Work Order ID: 54132

Parent Item: D3852-041RevA

Parent Item Name: Rib Assembly

Comments: Ipp rev B 09.11.24 updated process EC verified by:DD

Start Date: 02/12/2009

Required Date: 08/12/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3166-3RevA1		Manufactured	No			100	Each	7.0527	0.3789			
--------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Basket Hoop

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

53494

6

53494

6

Main Warehouse

WA

1.052689474

50033

0.0527

50618

0.1894

52058

0.81058947

D3759-1RevA

Manufactured No



Bushing

100	Each	10.0000
-----	------	---------

2.0000

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

WA

10

53442

10



SAD 09-12-02

3789

SP 09.12.04.

2 x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

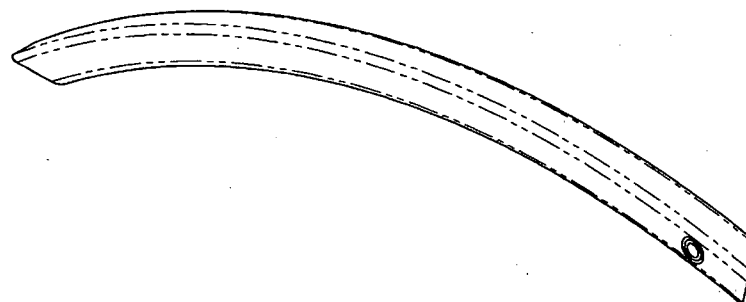
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



D3852-041 RIB ASSEMBLY

C



D3852-042 RIB ASSEMBLY

B

A

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

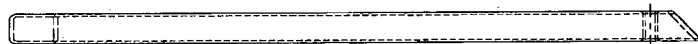
8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB

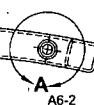
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54132
BT 09-12-01

RELEASE
08/11/08 MJP

I A	NEW ISSUE		MB	08.11.07
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3852 TITLE RIB ASSEMBLY		
DRAWN				
CHECKED				REV. A
MFG. APPR.				SHEET 1 OF 3
APPROVED				SCALE
DE APPR.				NTS
DATE	08.11.07			
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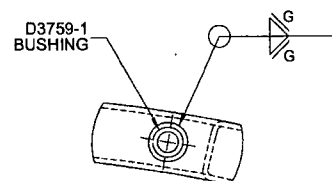


D3852-1
RIB



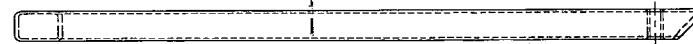
A6-2

D3852-041 RIB ASSEMBLY

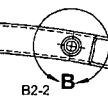


D3759-1
BUSHING

DETAIL A
SCALE 2X C5-2

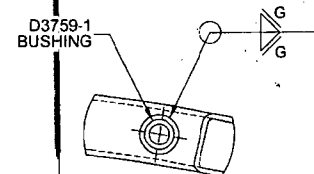


D3852-2
RIB



B2-2

D3852-042 RIB ASSEMBLY



D3759-1
BUSHING

DETAIL B
SCALE 2X C2-2

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	185	DRAWING NO. D3852	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
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